

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

Trim to Finished Dimensions

X/ 17/09/29

X/ 14/09/30

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Work Order ID 123906

Thursday, August 28, 2014 3:49:57 PM

123906

Page 3

Item ID: D4635-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Ceiling Panel, LH

Stop ***NS2***Start Date: 9/15/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/15/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	QC6- Inspect dimensions to drawing	0.00							
140	Dimensional Inspection								
QC	Memo	0.00							
Quality Control	Fill out Inspection Sheet Rev A								

DAS
27
9-89
14/10/17

150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
14-10-2

160	Packaging	0.00							
160									
Packaging	Memo	0.00							
Packaging									

DAS
27
9-89
14/10/17

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Picklist Print

Thursday, August 28, 2014 3:49:57 PM

Page 1

Work Order ID: 123906

123906

Parent Item: D4635-1

D4635-1

Parent Item Name: Fwd Ceiling Panel, LH

Start Date: 9/15/14

Required Date: 9/15/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B
Dwg. Update 12/11/08 DL IPP Rev. C Dwg Update
13/07/09 DL IPP Rev D Dwg Update, Material
Change 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	3,973.393	25.27	26			DAS 07 9-89
									**				
MI FXS 093-F6006-07													
GE PLASTICS LEXAN SHEET (Grey)													

Location	Loc Qty	Loc Code
MAT023	3973.39332	
114459	229.26	
123105	38	
124501	543.5	
m128668	181.35	
m129014	102.33332	
m129471	175	
m129738	2703.95	

14/09/02

26 sg A4

DQA: _____ Date: _____



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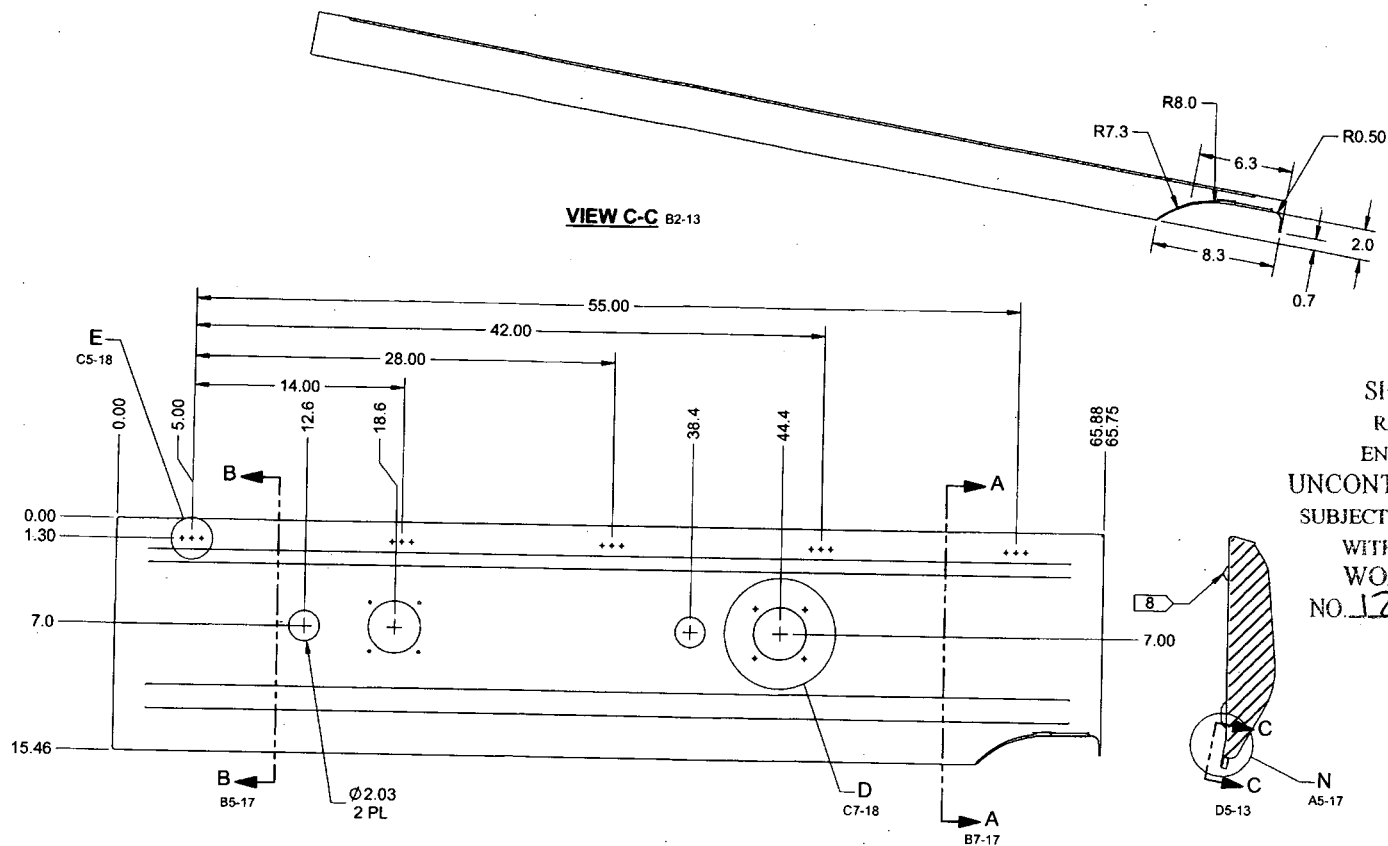
DART AEROSPACE LTD		Work Order:	123906
Description: LH Fwd Ceiling Panel		Part Number:	D4635-1
Inspection Dwg: D4635 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.00	+/-0.030	14.00	\		S Feb-21	
28.00	+/-0.030	28.00	\		S Feb-08	
42.00	+/-0.030	42.00	\		\	
55.00	+/-0.030	55.00	\		\	
5.00	+/-0.030	5.00	\		\	
12.6	+/-0.100	12.6	\		\	
18.6	+/-0.100	18.6	\		\	
38.4	+/-0.100	38.4	\		\	
44.4	+/-0.100	44.4	\		\	
1.3	+/-0.100	1.297	\		\	
7.0	+/-0.100	7.0	\		\	
7.00	+/-0.030	7.00	\		\	
Ø2.03	+0.012/-0.001	2.047	\		\	
Ø0.191	+0.005/-0.001	.192	\		\	
Ø3.50	+0.012/-0.001	3.514	\		\	
3.300	+/-0.010	3.298	\		\	
1.650	+/-0.010	1.6497	\		\	
Ø0.129	+0.005/-0.001	0.1297	\		\	
1.300	+/-0.010	1.3007	\		\	
0.650	+/-0.010	0.6498	\		\	
0.35 - 0.40	+/-0.030	0.374	\		\	
0.30	+/-0.030	0.317	\		\	
0.50	+/-0.030	0.506	\		\	

Measured by:	^{DAS} 27	Audited by:	^{DAS} 36	Preliminary Approval:	
Date:	14/9/17	Date:	14-10-2	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 123906MLS
14-08-29

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXX.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.39 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-1 PER TOOL DT9839
- 10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-1 LH, FWD CEILING PANEL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	DC	D4635	SHEET 13 OF 18
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	OUTBOARD CEILING PANELS	NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SECTION A-A
SECTION A-A' OPPOSITE
SCALE 2X

AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE
SCALE 2X

SECTION B-B B7-13
SCALE 2X B7-14

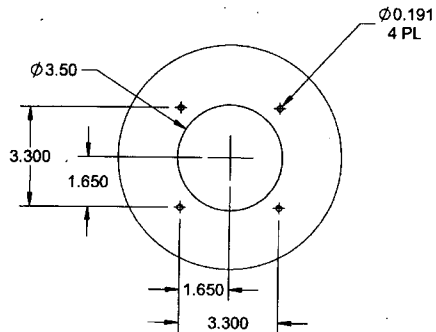
AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE
SCALE 2X

SECTION G-G B4-15
SCALE 2X B4-16

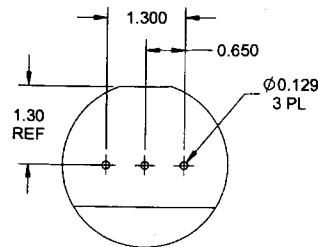
SECTION K-K C6-16
SCALE 2X

2014-01-22

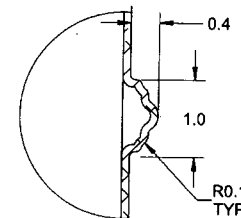
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>BC</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>BC</i>	D4635	SHEET 17 OF 18
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	OUTBOARD CEILING PANELS NTS	
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND MAY BE USED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	



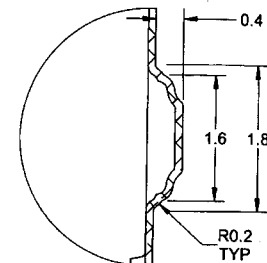
DETAIL D
SCALE 2X
B4-13
B3-14
B5-15
B5-16



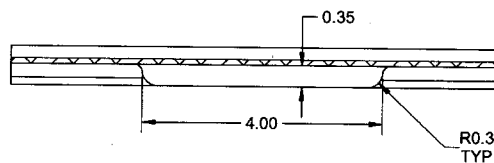
DETAIL E
SCALE 4X
C7-13
B6-14
C6-15
B5-16



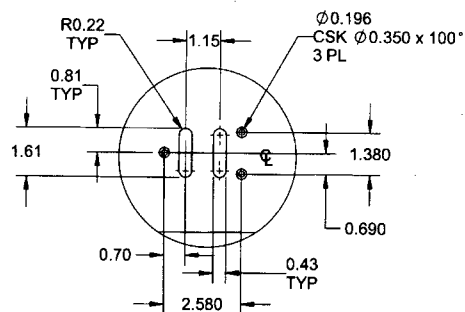
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SCALE 1.5X
B2-17
B4-17
C5-17
C7-17



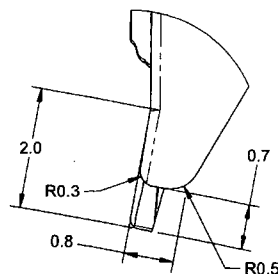
DETAIL M
SCALE 1.5X
C2-17
C3-17
C5-17
C7-17



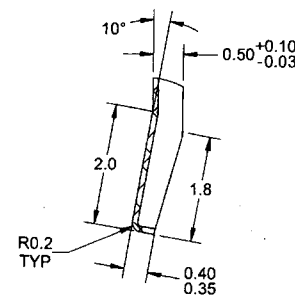
SECTION I-I
SCALE 4X
B5-16



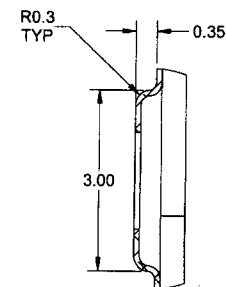
DETAIL Q
SCALE 2X
C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

RELEASED
2014-01-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4635	SHEET 18 OF 18
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	OUTBOARD CEILING PANELS	NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	